

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023370**Date Inspected:** 21-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu Yo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

BAY 14

Orthotropic Box Girder (OBG)

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Side Plate to Corner Assembly SP 136A to SP 163A for Segment 9EW. The weld joint no. SEG057-003 is in progress. The welder is identified as 045203. Welder was welding in 1G (Flat) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-U2-F.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Plate between SP 108A to SP 135A for Segment 9DW. The weld joint no. SEG055A-001 is in progress. The welder is identified as 25050. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Plate between SP 106A to SP 133A for Segment 9BW. The weld joint no. SEG055A-001 is in progress. The welder is

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identified as 25050. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Deck Panel to Corner Assembly DP 274A to CA 13A for Segment 6BW. The weld joint no. SEG 029\*-008 is in progress. The welder is identified as 045265. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Deck Panel DP 275A to DP 515A for Segment 6CW. The weld joint no. SEG 031\*-032 is in progress. The welder is identified as 045265. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-L2C-S-2.

The designated ZPMC CWI for the West Line is Mr. Shen Fu Yoo and QC Mr. Li Ming Yang, Mr. Liu Wan Ning and Mr. Liu Rudan for Bay 14.

### Orthotropic Box Girder (OBG) Trial Assembly Area

This QA Inspector performed Dimensional Inspection as per Dimension Control Plan (DCP) for U-Ribs 39 Nos. Longitudinal Diaphragm 2 Nos., T-sections for Bottom Plate 18 Nos. and T-sections for Side Plates 19 Nos. each side for 3BW and 4AE generated a report for West side segments and dimension report submitted to Mr. Rory.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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